

Date: Friday, 23/03/2007 6:06:58 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CONSOLE BRACKET HI-SLOPE		
Job Number	: 31334		Part Number	: D2606		
Estimate Number	: 11004		Drawing Number	: D2606 REV A1		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 23/03/2007	S.O. No. : N/A	Drawing Revision	: A1		
Prsh't Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 10/04/2007 Qty: 20 Um: Each		
Previous Run	: 31334					
Written By	:					
Checked & Approved By	:					
Comment	: Est. D 98.11.26 Added Inspection DM Est Rev:E Now On Waterjet 07-03-22 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S040	2024-T3 .040 sheet	
		Comment: Qty.: 0.1582 sf(s)/Unit Total : 3.1647 sf(s) 2024-T3 .040 sheet Material: 2024-T3 (QQ-A-250/4) 0.040" thick Stack of 10 (M2024T3S.040) Batch m104025	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2606 Dwg Rev: A1 Prog Rev: A1	 <i>m1 07 04 19</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	 <i>m1 07 04 19</i>
4.0	QC8	SECOND CHECK	 <i>J0704-21</i> <i>20 counted.</i>

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE BRACKET HI-SLOPE

Job Number: 31334

Part Number: D2606

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	BRAKE NC	NC BRAKE
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Barcode

Comment: NC BRAKE

Deburr GAD 07/05/03

(20)

Form as per Dwg D2606

SB 07/05/04 (20)

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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(20X)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m-h 07/05/08

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

GAD 07/05/08 (20)

8.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0	QC21	FINAL INSPECTION/W/O RELEASE
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(20)

Comment: FINAL INSPECTION/W/O RELEASE

G 07/05/08

Job Completion



C 07/05/08

5.1

QCS 07/05/07 (20)

Date: Tuesday, 3/20/2007 12:03:31 PM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	CONSOLE BRACKET HI-SLOPE
Job Number	: 31334		
Estimate Number	: 11004		
P.O. Number	:	Part Number	: D2606
This Issue	: 3/20/2007	S.O. No.	: D2606 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: A1
Previous Run	: 25142	Material	:
Written By	:	Due Date	: 4/10/2007
Checked & Approved By	: <u>John D. 03.20</u>	Qty:	20
Comment	: Est. / D 98.11.26 Added Inspection DM	Um:	Each
Additional Product			
Job Number:		Description :	
Seq #:	Machine Or Operation:	Description :	
1.0	M2024T3S040	2024-T3 .040 sheet	
Comment: Qty.: 0.1582 sf(s)/Unit Total : 3.1647 sf(s)			
2024-T3 .040 sheet			
Material: 2024-T3 (QQ-A-250/4) 0.040" thick			
Stack of 10			
(M2024T3S.040) Batch			
WJH			
2.0	SHEAR	SHEAR	
Comment: SHEAR			
Cut Blank per template DT8247			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment: HAAS CNC VERTICAL MACHINING #1			
Machine per folio D2606			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
5.0	QC8	SECOND CHECK	
Comment: SECOND CHECK			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
0705.07	5.0	Add QC S Perm.Change	2	0705.07	20	0705.07	0705.07
	s	QcS					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/20/2007 12:03:31 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE BRACKET HI-SLOPE

Job Number: 31334

Part Number: D2606

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr

Form as per Dwg D2606

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005.4.1

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31334
Description: Console Bracket	Part Number:	D2606
Inspection Dwg: D2606 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>M. M</u>
Date:	01/04/19

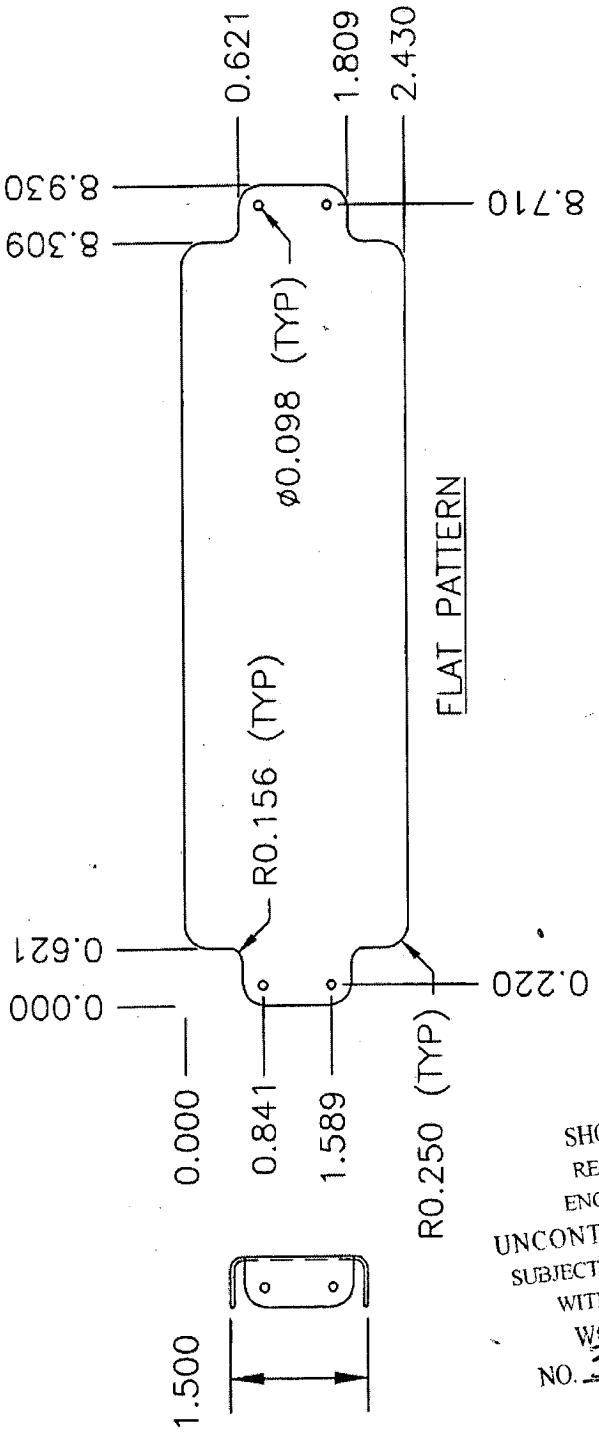
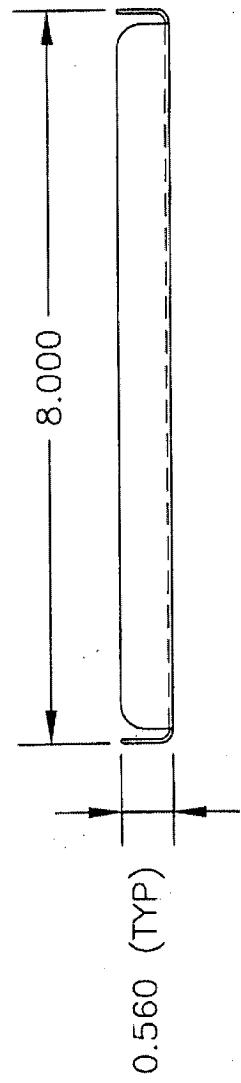
Audited by: J
Date: 07.04.24

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	SJL

DART

DESIGN <i>J</i>	DRAWN BY <i>BW</i>	DART AEROSPACE LTD. VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>J</i>	DRAWING NO: D2606	REV. A SHEET 1 OF 1
DATE 97.10.23		TITLE CONSOLE BRACKET	SCALE 1:2
A	97.10.23	D2606 WAS D206-547-27	
A1 CRAFT	02.06.04	ADD FINISH	

RELEASED97.11.04 KE
TSR A421

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31334

MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
PROFILE CONTROLLED BY FOLIO H2606
BEND RADIUS 0.093
FINISH: CHEMICAL CONVERSION COAT PER DART QSI & S 4.1 A1